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3.5h

START 13h30

D4776-1

Job Sheet 182435



Part No: D4776-1

Job Qty: 10 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/7/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs		9/7/18	0.54	5.32	Doosan		
105	QC	10 pcs		9/7/18	0.00	0.00	QC2 Machining-3		
111	QC	10 pcs		9/7/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	10 pcs		9/7/18	0.00	0.29	HandFinish1		
113	QC	10 pcs		9/7/18	0.00	0.00	QC7-4		
115	Powdercoat	10 pcs		9/7/18	0.00	0.12	Powdercoat1		
116	QC	10 pcs		9/7/18	0.00	0.00	QC3		
130	Packaging	10 pcs		9/7/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea		9/7/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: ____ 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M 83983 START: 7:30 OUT: 300° FINISH: 8:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	2.9000 ft (.29 ea)	90-Start up Operation	5069913

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	3	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850	8805	
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428	44	
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350	378	
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615	623	

5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720	1.75	
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470	3.501	
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000	.031	
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	.062	Radius
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	.197	Diameter
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	.262	Diameter
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	.409	Radius
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100	1.1305	
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178	.1875	
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160	.191	
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470	.501	
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740	.7505	
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	.401	Diameter
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	.125	Radius
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750	.756	
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130	.150	
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	45°	Angle

DART
AEROSPACE

Container No: S117174



Part: D4776-1

Job No: 182435

Serial No/Batch: S117174

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/10/18